

Date: Tuesday, 15/04/2008 7:30:10 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services      Drawing Name : LID PRO ARM ASSEMBLY (SHORT)  
 Job Number : 38597  
 Estimate Number : 10258  
 P.O. Number :  
 This Issue : 15/04/2008      S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / /      Type : SMALL /MED FAB  
 Previous Run : 37387  
 Part Number : D2332041  
 Drawing Number : D2332  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 22/04/2008      Qty: 28 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5KJ/  
 RF

## Additional Product

Job Number:



Seq. #:      Machine Or Operation:      Description :

1.0      M304TR1000W049      304 RD Tube 1.0" x .049W



Comment: Qty.: 0.4331 f(s)/Unit      Total: 10.3950 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

~~M107166~~

M105240

(12)

M107573

(16x)

2.0      M304R250      1/4" 304 SS Roundbar



Comment: Qty.: 0.1092 f(s)/Unit      Total: 2.6208 f(s)      3-276

Material: Ø0.250" 304SS Rod

Batch ~~M105750~~

(12)

M107387

08/04/28

3.0      SMALL FAB 1      SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

08/04/28 (30)

4.0      M304TR0500W035      304 RD Tube .500 x .035W



Comment: Qty.: 1.2502 f(s)/Unit      Total: 30.0048 f(s)

304 RD Tube .500 x .035W

M107166-48

M106593

(12)

08/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/04/2008 7:30:10 AM  
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Job Number: 38597

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012  
(Note: Make (2) D2332-11 Prop Arms per assembly.)

*Box 4/15 (48)*

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

*Box 4/28*  
*30x*

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

*(P/D)*

A/R SS Rod Batch: *M107091*

*Box 4/28*  
*08-04-28 SP*

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-04-29*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Box 4/22 (28)*

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

*Box 4/30 (28)*

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number  
1 AN4-4A

Description  
Bolt

Batch

*M101291 (192)*


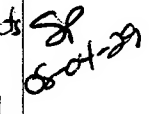

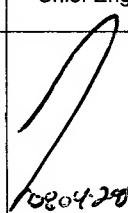
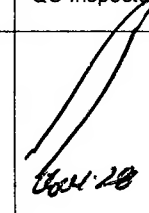
*M106918 (192)*

*Box 4/30*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: N/A Fault Category: Prod / FMS - Log NCR: Yes No DQA: S Date: 08/05/01  
QA: N/C Closed: A Date: 08/05/01

NCR: 38597		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/29	# 6	During inspection it was found that 2 arms have a foreign object inside them. R.C. on arms went clean out exact per welding		Ensure that all foreign objects are removed after drilling. Add a comment at the beginning of 6.2 "Ensure to remove all foreign objects" prior to welding.	 08/04/29	 08/04/29	 08/04/29	 08/04/29
				Scrap and Destroy Qty (42) no replace.				

NOTE: Date & initial all entries

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Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 38597

Part Number: D2332041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	AN960JD416L	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty	Part Number	Description
3	AN960JD416L	Washer

Batch

M107008

EB08/04/30

12.0	MS21042L4	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty	Part Number	Description
1	MS21042L4	Nut (or -4)

Batch

M106051

EB08/04/30

13.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/30 428

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PK 8/4/30 (28)

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/05/01 JF

Job Completion



U 08/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

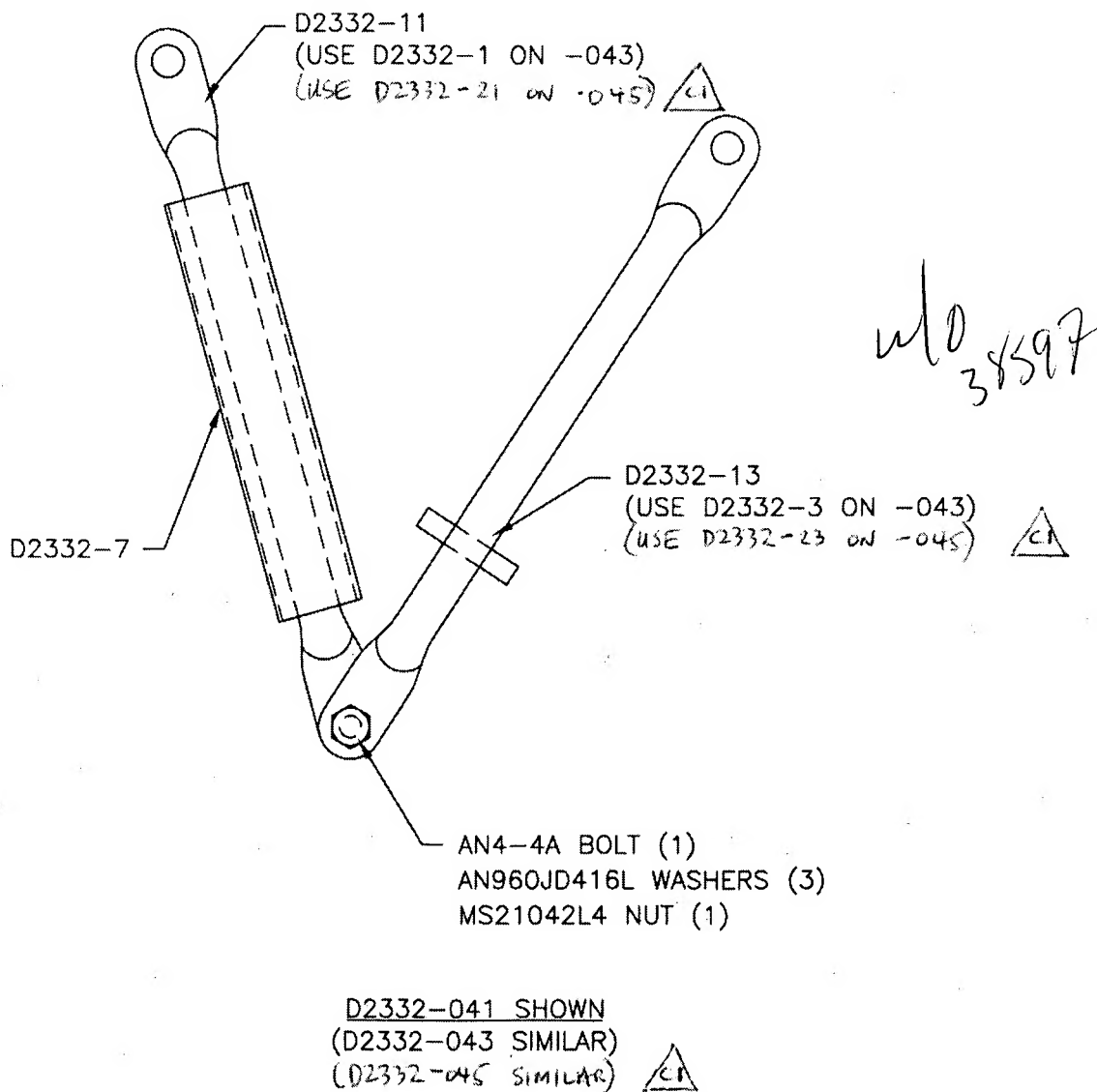
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[initials]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED  
03.07.04 *[initials]*



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



**DART****DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. C

SHEET 2 OF 2

DESIGN

CHECKED

DRAWN BY

D2332

D2332

LID PROP ASSEMBLY

DATE

SCALE

03.07.03

TITLE

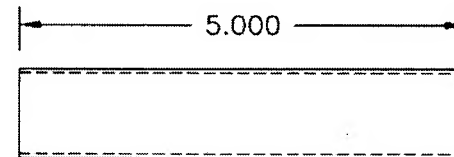
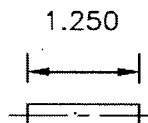
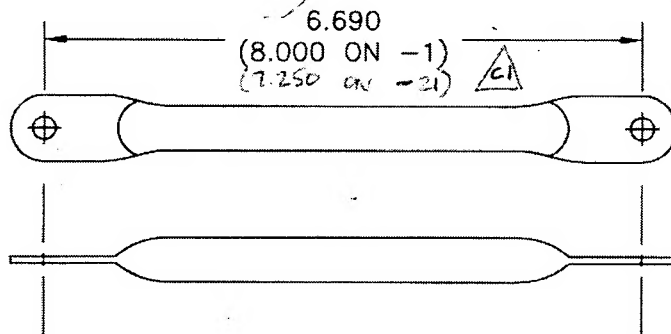
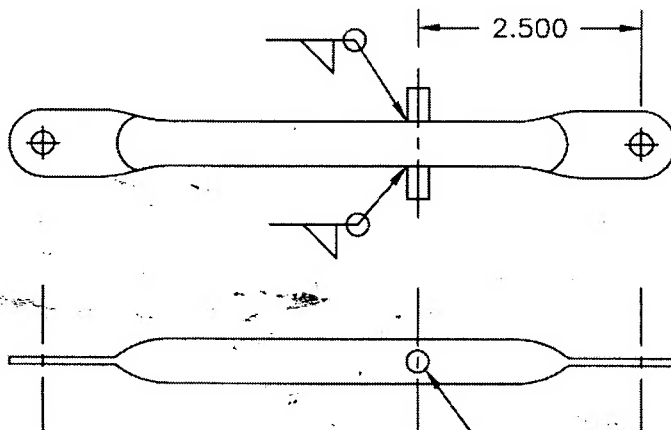
1:2

C 03.07.03

MAKE -041 PROP 6.69" LONG (LID)  
MAKE -043 PROP 8.00" LONG (M)

C1 03.08.06

ADD -045 PROP (7.25" LONG)

D2332-7 LOCKING COLLARD2332-5 STOP PIND2332-11 PROP  
(D2332-1 SIMILAR)D2332-13

M/F: D2332-11 &amp; D2332-5

(D2332-3 SIMILAR - M/F D2332-1 &amp; D2332-5)

(D2332-23 SIMILAR - M/F D2332-21 &amp; D2332-5)



## NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

